

Claims

1. A rubber crawler track, comprising:

a rubber crawler body shaped as an endless belt made of rubber elastic body;

a layer comprising a majority of steel cords embedded in said rubber crawler body;

and

core metals embedded in said rubber crawler body at a fixed interval in a crawler circumferential direction,

each of said core metals comprising:

an engaging portion formed at the center of a core metal length direction;

guide protrusions for preventing wheel run-off;

wing portions,

said guide protrusions and said wing portions formed at both sides of the engaging portion;

and

horizontal protrusions formed to side planes of the core metal in a width direction of at least one of the both sides of said engaging portion where are within a thickness of the wing portion in a core metal vertical direction and an area of anti-tread side portion below than the thickness,

said horizontal protrusions facing between adjacent core metals in the crawler circumferential direction overlapping within a fixed length of their ends in a crawler width direction and in a crawler thickness direction;

wherein a distance “r” in the crawler circumferential direction between the ends of the horizontal protrusions is expressed as $\Delta r \leq r \leq 2 \Delta r$ when the rubber crawler track is horizontal.

2. A rubber crawler track, comprising:

 a rubber crawler body shaped as an endless belt made of rubber elastic body;

 a layer comprising a majority of steel cords embedded in said rubber crawler body;

and

 core metals embedded in said rubber crawler body at a fixed interval in a crawler circumferential direction,

each of said core metals comprising:

 an engaging portion formed at the center of a core metal length direction;

 guide protrusions for preventing wheel run-off;

 wing portions,

 said guide protrusions and said wing portions formed at both sides of the engaging portion;

and

 horizontal protrusions formed to side planes of the core metal in a width direction of at least one of the both sides of said engaging portion where are within a thickness of the wing portion in a core metal vertical direction and an area of anti-tread side portion below than the thickness,

 said horizontal protrusions facing between adjacent core metals in the crawler circumferential direction overlapping within a fixed length of their ends in a crawler width direction and in a crawler thickness direction;

 wherein a tapered horn portion is provided to an end of the horizontal protrusion of one side of the adjacent core metals.

3. A method of producing a core metal for rubber crawler track, embedded in an endless belt-shaped rubber crawler body made of rubber elastic body, said rubber crawler track including a majority of steel cords stratifiedly embedded at a fixed interval in a crawler circumferential direction, comprising:

 forming an engaging portion at the center of said core metal in a core metal length direction;

forming guide protrusions for preventing wheel run-off and wing portions to both sides of said engaging portion;

providing horizontal protrusions to side planes in a core metal width direction of at least one side of the both sides of said engaging portion within a thickness of the wing portion in a core metal vertical direction and an area of tread side below than the thickness;

forming a parting plane of a mold for producing the core metal so as to be parted longitudinally in the core metal width direction;

shifting said parting plane laterally on the guide protrusions at the center of the core metal wing portions in a direction that the guide protrusions are shifted; and

shifting trimming tapers of guide tops of the guide protrusions left and right from the center of the core metal.